

Date: Thursday, 3/27/2008 7:41:50 AM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI ACCESS HANDLE WELDMENT ASS'Y, RH
Job Number : 38222	
Estimate Number : 10947	
P.O. Number :	Part Number : D2480012
This Issue : 3/27/2008 S.O. No. :	Drawing Number : D2480 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A1
Previous Run : 38089	Material :
Written By :	Due Date : 4/10/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JD 08.3.27</u>	
Comment : Est. C1 03.01.09 Added Powder Coat	

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2478	Lower Arm
-----	-------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lower Arm

Pick:

Qty	Part number	Description	Batch
1	D2478	Heli Access Handle	B38146 4x 08-07 SP

2.0	D2479	Upper Arm
-----	-------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Upper Arm

Pick:

Qty	Part number	Description	Batch
1	D2479	Heli Access Handle	B38228 3x 08-07 - SP

3.0	D2481	Lower Mount Plate
-----	-------	-------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lower Mount Plate

Pick:

Qty	Part number	Description	Batch
2	D2481	Mounting Plate	B38147-8x 08-07 - SP

4.0	D2482	Upper Mount Plate
-----	-------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Upper Mount Plate

Pick:

Qty	Part number	Description	Batch
1	D2482	Mounting Plate	B23504 - 4x 08-07 - SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/27/2008 7:41:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS HANDLE WELDMENT ASS'Y, RH

Job Number: 38222

Part Number: D2480012

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Template DT 8333 (DT 2480 CJ)

*B 107051*

*SP 08-07-2. 4X.*

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 08-07-03 (C)*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/02/03 4X B.38222*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

*M 107925*

*BL 08-07-0*

*38222*  
*303 MTAG*  
*S.032 13.57*  
*#1 398.0 F*  
*#2 --- F*  
*#3 --- F*  
*#4 --- F*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*18 08/07/04*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*PPD 38090*

*18 08/07/04 (XU)*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/07/08*

Job Completion



*MF 08-07-04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

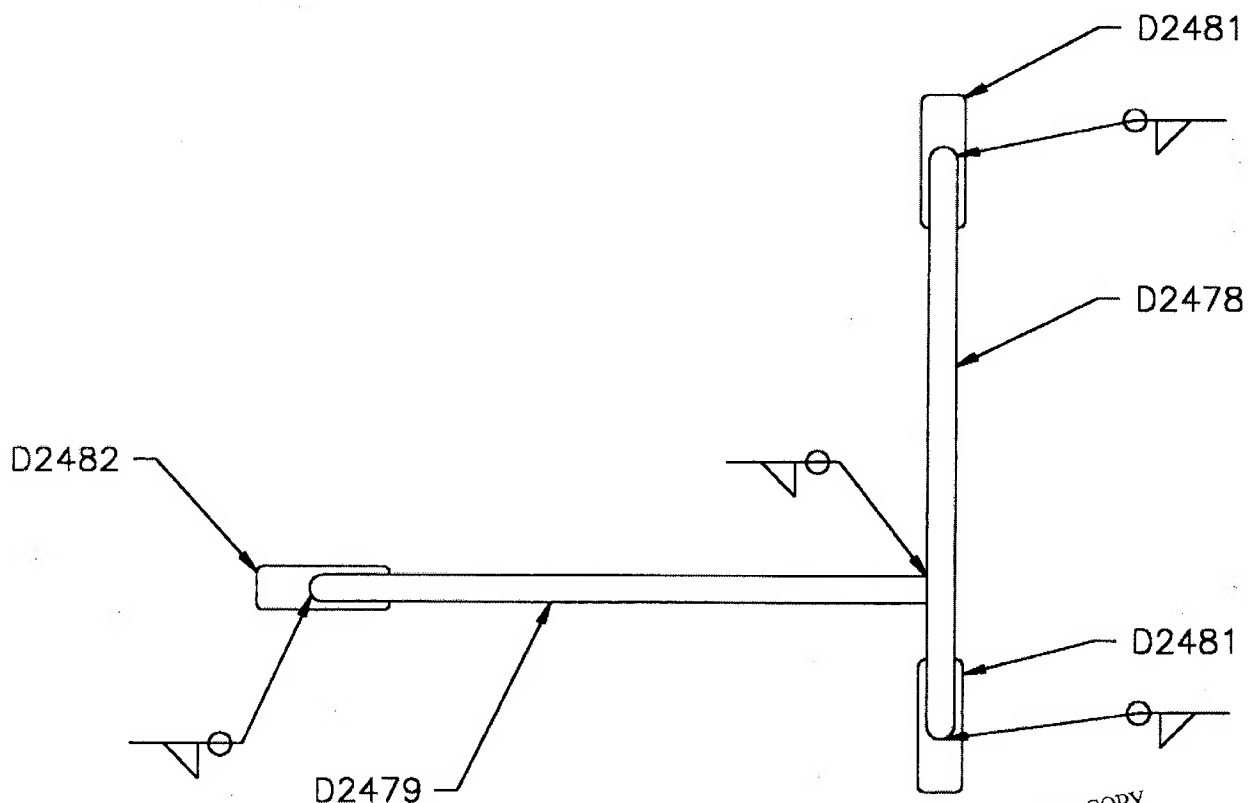
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN B WILLIAMS	DRAWN BY MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2480	REV. A SHEET 1 OF 1
DATE 96:05:14		TITLE HANDLE WELDMENT ASSEMBLY	SCALE 6:1
A1 <i>05.06.23</i>		ADDED POWDER COAT	

RELEASED  
96/06/02 DS



D2480-011 LH SHOWN  
D2480-012 RH OPPOSITE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38222

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER QSI 004  
A1 2) POWDER COAT WHITE GLOSS (REF: 4,3,5,2) AS PER QSI 005